

# Work Order ID 52974

October 20, 2009 8:45:21 AM



Page 1

Item ID: D3404-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: GHW Lug

Start Date: 10/21/2009 Start Qty: 50.00



Cust Item ID:

Required Date: 10/26/2009 Req'd Qty: 50.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-10-20

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3404	Rev C								

100

0.00



BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank: 2.750" long

amb 09/10/30

50

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine as per Folio FA555 and Dwg D3404 Dwg Rev: C Folio Rev: C  
C □2-Deburr

M.A 09/10/30  
DA 09/11/01

51



120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo


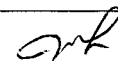

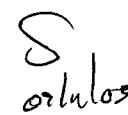
Quality Control

M.A 09/10/30  
DA 09/11/01

51

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3404-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: A Date: 09.11.06  
 Resolution: Acceptable Disposition: Use as-is QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 52974		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/10/30	110	$\phi .510^{+0.008}_{-0.001}$ hole deviate from .510 to .525 re: Part had moved during first operation (2 part)	 09.11.02 pc QSI 042	Replace Batch # <u>112697</u> Acceptable. GHLW HOLE ONLY. NOT FOR FLIGHT LOADS	H.A 09/10/31	 09/11/03	 09.11.02 pc QSI 042	 S orlulos

NOTE: Date & initial all entries

**Work Order ID 52974**

October 20, 2009 8:45:21 AM



Page 2

Item ID: D3404-1

Accept



Setup Start



Revision ID: C

Item Name: GHW Lug

Stop



Start Date: 10/21/2009 Start Qty: 50.00



Cust Item ID:

Required Date: 10/26/2009 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

mf  
09/11/03

51

0

140

Identify as per dwg & Stock Location: RRc L 0.00

Packaging

Memo

0.00

Packaging

09/11/03 (51)

150

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

09/11/03

mf  
09-11-03

# Picklist Print

October 20, 2009 8:45:21 AM

Page 1

Work Order ID: 52974

Parent Item: D3404-1RevC

Parent Item Name: GHW Lug

Comments:

Start Date: 10/21/2009

Required Date: 10/26/2009

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.750X2.500		Purchased	No			100	f	36.4000	12.0579			

304 BAR .750 X 2.50

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

36.4

112663

14

→ 112697

22.4

M110777 X 28

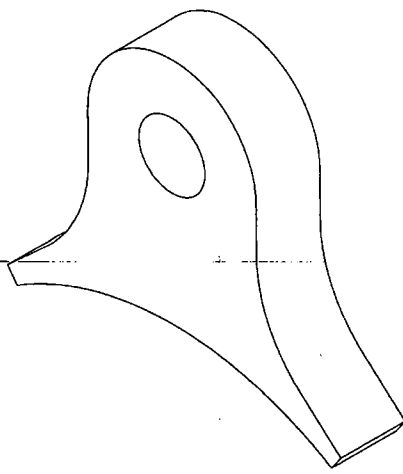
6.8  
6737

5.2937

am 09/10/30



#52974



D3404-1 GHW LUG

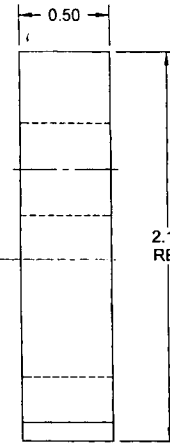
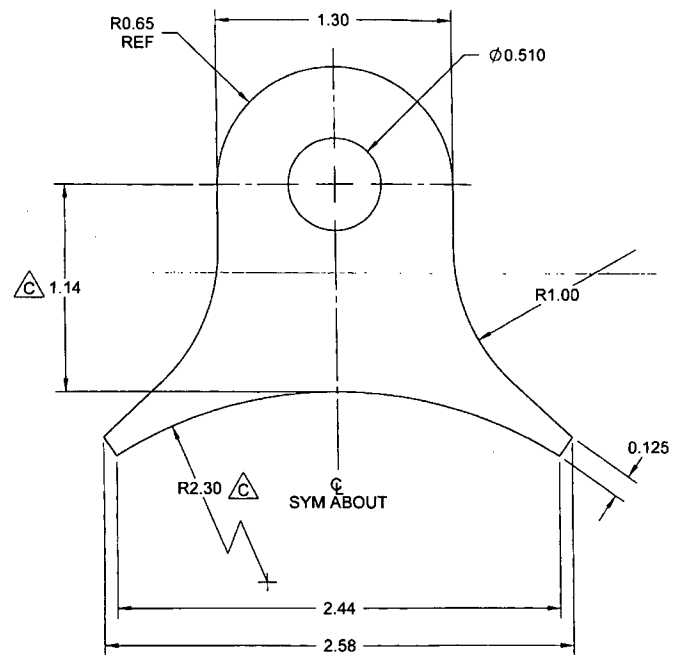
RELEASED  
08/12/02

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
DATE	08.12.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

#52974



RELEASED  
08/12/18 JH/B

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED		DRAWING NO. D3404	REV. C SHEET 2 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		GHW LUG	NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.12.02		